

Work Order ID 146317

Tuesday, May 17, 2016 2:17:03 PM

146317

Page 1

Item ID: PB67-43001-09

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Blade Fold Assembly Weldment

Start Date: 5/18/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/30/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: mf Date: 16-5-17

Tooling:

Date:

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr**Revision Nbr**

B67-43001-09

D

100

Weld per dwg A/R Aluminum rod Batch: 131562 0.00
Large Fab***100***

Large Fab

Memo

1.22

Large Fab

1- Assemble parts on jig DT8814 and weld as per dwg PB67-43001

**** Ensure no burn thru after welding in tube -235 and -229 only where bushing -
265 *****

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Memo

0.00

Quality Control

2 JUN 06 2016 DAS
24
9-892 16-06-07 DAS
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

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Page 2

0.02

② _____

JUN 13 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Page 3

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Blade Fold Assembly Weldment

Start Date: 5/18/2016 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 6/30/2016 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

Identify as per dwg & Stock Location: **ME222** 0.00***150***

Packaging

Memo

0.02

Packaging

2 **JUN 15 2016** **DAS 24 9-00**

160

QC21- Final Inspection - Work Order Release 0.00

160

QC

Memo

0.20

Quality Control

MCS **JUN 16 2016****MCS** **JUN 15 2016**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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☐ OTHER : _____					

Picklist Print

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Page 1

Work Order ID: 146317

146317

Parent Item: PB67-43001-09

PB67-43001-09

Parent Item Name: Aft Blade Fold Assembly Weldment

Start Date: 5/18/2016

Required Date: 6/30/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-06-25 new issue DD verified by:ec IPP RevB
10.09.24 per revC dwg EC verified by:DD IPP REV:C 14.12.15
AS PER DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-203W		Manufactured	No			100	Each	12.0000	1	2			DAS
PR67-43001-203W									**			JUN 06 2016	24 9-89
Square Tube Weldment													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MEZZ				12					
				139208				12					
PB67-43001-229W		Manufactured	No			100	Each	5.0000	1	2			DAS
PR67-43001-229W									**			JUN 06 2016	24 9-89
Outer Tube Weldment													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA004				5					
				139199				5					
PB67-43001-239W		Manufactured	No			100	Each	3.0000	1	2			DAS
PR67-43001-239W									**			JUN 06 2016	24 9-89
Square Tube Weldment													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WWA04				3					
				139197				3					
PB67-43001-201		Manufactured	No			100	Each	16.0000	2	4			DAS
PR67-43001-201									**			JUN 06 2016	24 9-89
Square Tube													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				Mezz2				16					
				139209				16					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
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Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐			

Picklist Print

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Page 2

Work Order ID: 146317

146317

Parent Item: PB67-43001-09

PB67-43001-09

Parent Item Name: Aft Blade Fold Assembly Weldment

Start Date: 5/18/2016

Required Date: 6/30/2016

Start Qty: 2.00

Required Qty: 2.00

PB67-43001-209

Manufactured

No

100

Each

10.0000

1

2

PR67-43001-209

Square Tube

**

JUN 06 2016

DAS
24
9-89

Location

Loc Qty

Loc Code

Mezz2

10

139206

10

PB67-43001-211

Manufactured

No

100

Each

66.0000

6

12

PR67-43001-211

Square Tube

**

JUN 06 2016

DAS
24
9-89

Location

Loc Qty

Loc Code

Mezz2

66

139201

66

PB67-43001-213

Manufactured

No

100

Each

13.0000

2

4

PR67-43001-213

Flanged Hook

**

JUN 06 2016

DAS
24
9-89

Location

Loc Qty

Loc Code

Mezz2

13

112764

1

139200

12

PB67-43001-235

Manufactured

No

100

Each

5.0000

1

2

PR67-43001-235

Outer Tube

**

JUN 06 2016

DAS
24
9-89

Location

Loc Qty

Loc Code

Mezz2

5

139198

5

Tuesday, May 17, 2016 2:17:03 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 3

Work Order ID: 146317

146317

Parent Item: PB67-43001-09

PR67-43001-09

Parent Item Name: Aft Blade Fold Assembly Weldment

Start Date: 5/18/2016

Required Date: 6/30/2016

Start Qty: 2.00

Required Qty: 2.00

PB67-43001-243

Manufactured No

100

Each

7.0000

1

2

PR67-43001-243

Tube Handle Extension

**

JUN 06 2016

DAS
24
9-89

Location

Loc Qty

Loc Code

Mezz2

7

133673

3

139196

4

PB67-43001-277

Manufactured No

100

Each

4.0000

1

2

PR67-43001-277

Contoured Male Eye

**

JUN 06 2016

DAS
24
9-89

Location

Loc Qty

Loc Code

Mezz2

4

183674

4

PB67-43001-311

Manufactured No

100

Each

12.0000

2

PR67-43001-311

Restraint

**

JUN 06 2016

DAS
24
9-89

Location

Loc Qty

Loc Code

Mezz

1

90935

1

Mezz2

11

112691

1

139192

10

D3440-9

Manufactured No

100

Each

8.0000

1

2

D3440-9

Tube Detent Clip Base (Supersedes B67-43001-241)

**

JUN 06 2016

DAS
24
9-89

Location

Loc Qty

Loc Code

Mezz2

8

139210

8

Tuesday, May 17, 2016 2:17:03 PM

Shop Packet Print

Page 3

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WORK ORDER NON-CONFORMANCE / UPDATE

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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Parent Item: PB67-43001-09

PB67-43001-09

Parent Item Name: Aft Blade Fold Assembly Weldment

Start Date: 5/18/2016

Required Date: 6/30/2016

Start Qty: 2.00

Required Qty: 2.00

D3440-13

Manufactured No

100

Each

8.0000

1

2

D3440-13

Bracket (Supersedes B67-43001-273)

JUN 06 2016

DAS

24

9-88

Location

Loc Qty

Loc Code

Mezz2

8

139211

8

2

Tuesday, May 17, 2016 2:17:03 PM

Shop Packet Print

Page 4

DQA: _____ Date: _____

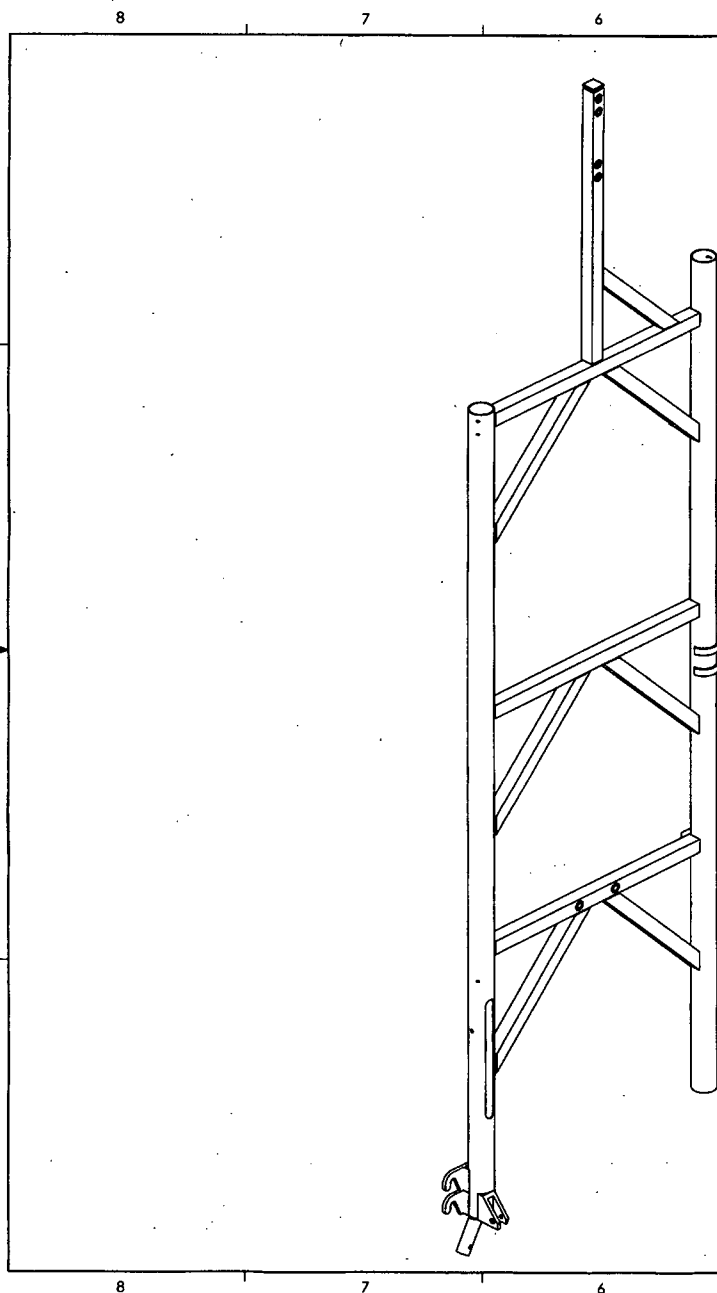


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Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
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ITEM	QTY	P/N	DESCRIPTION
	X	B67-43001-09	AFT BLADE FOLD ASSEMBLY WELDMENT
1	2	B67-43001-201	SQUARE TUBE
2	1	B67-43001-203W	SQUARE TUBE WELDMENT
3	1	B67-43001-209	SQUARE TUBE
4	6	B67-43001-211	SQUARE TUBE
5	2	B67-43001-213	FLANGED HOOK
6	1	B67-43001-229W	OUTER TUBE WELDMENT
7	1	B67-43001-235	OUTER TUBE
8	1	B67-43001-239W	SQUARE TUBE WELDMENT
9	1	B67-43001-243	TUBE HANDLE EXTENSION
10	1	B67-43001-277	CONTOURED MALE EYE
11	2	B67-43001-311	RESTRAINT
12	1	D3440-9	TUBE DETENT CLIP BASE
13	1	D3440-13	BRACKET

MF
146317

RELEASED
2014-12-08

D	REVISE BOM AND ANNOTATIONS TO INCORPORATE -203W/-229W/-239W WELDMENTS. DELETE DETAIL C (SH 2, 3); REASON: TO FACILITATE MANUFACTURING	DB	14.07.24
C	REDRAWN PREMIER AVIATION DRAWING IAW DART OSI 018 AND OSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 6 OF PREMIER AVIATION DRAWING #B67-43001. REASON: SEE PAR#09-011	MB	10.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		B67-43001-09	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	AFT BLADE FOLD ASSY WELDMENT	NTS
DATE	14.07.24	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____

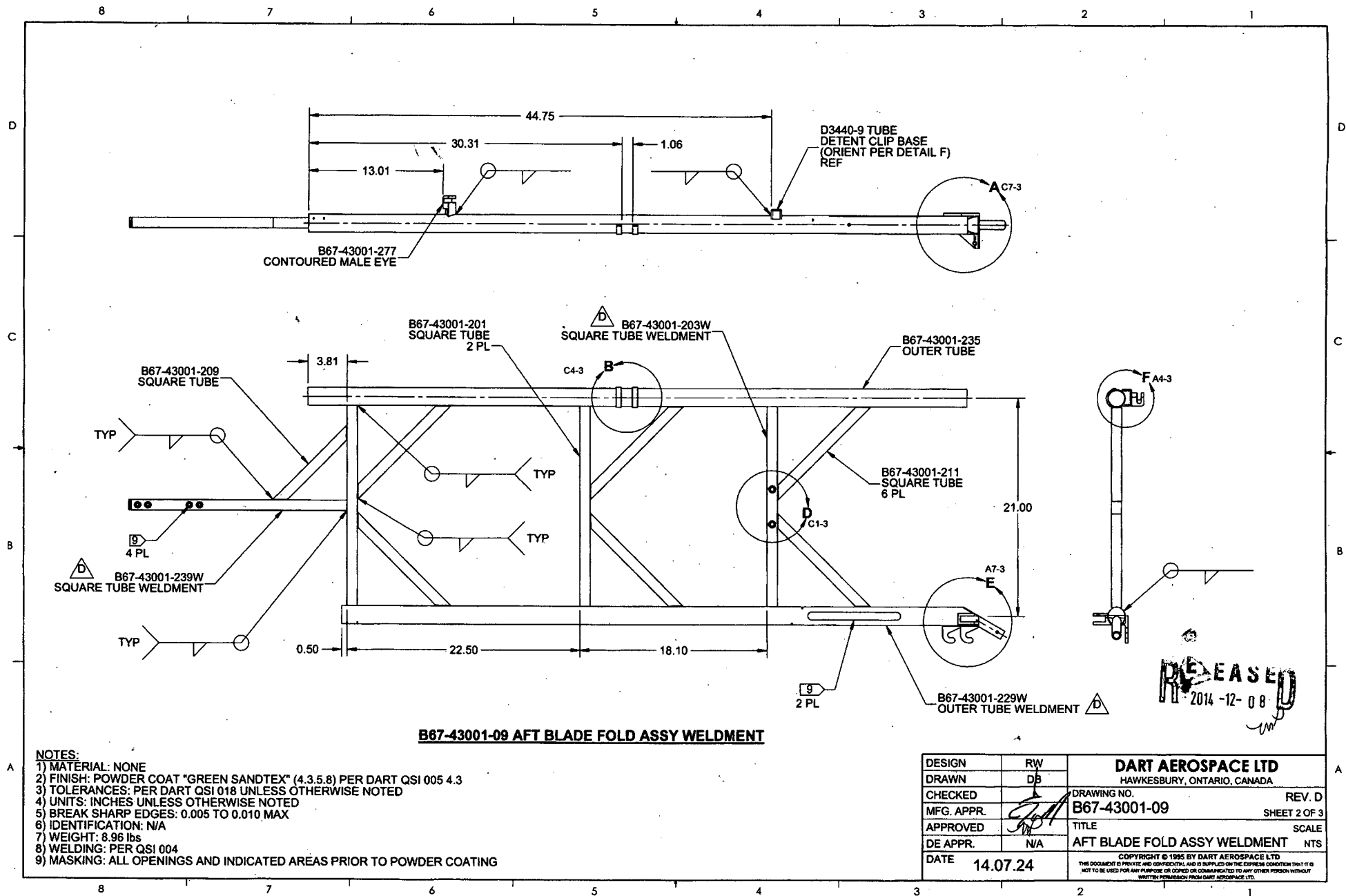


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									



DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

MATE WITH TOP SURFACE OF LOWER HOOK AND ALIGN WITH CENTERLINE OF OUTER TUBE

ALIGN WITH BOTTOM EDGE OF END CAP AND CENTERLINE OF OUTER TUBE

ALIGN WITH CENTERLINE OF OUTER TUBE AND FLUSH WITH ANGLED CUT

B67-43001-243
TUBE HANDLE EXTENSION
REF

ALIGN WITH CENTERLINE OF OUTER TUBE AND TO BOTTOM SURFACE OF END CAP

D3440-13
BRACKET

DETAIL A D3-2
SCALE 4X

B67-43001-229W
OUTER TUBE WELDMENT
REF

MASK INSIDE SURFACES OF BRACKET PRIOR TO POWDER COATING

B67-43001-243
TUBE HANDLE EXTENSION

B67-43001-213
FLANGED HOOK
2 PL

MASK INSIDE SURFACE OF HOOK PRIOR TO POWDER COATING

DETAIL E B3-2
SCALE 4X

B67-43001-311
RESTRAINT
2 PL

MASK ALL AROUND TUBE PRIOR TO POWDER COATING

B67-43001-235
OUTER TUBE
REF

DETAIL B C5-2
SCALE 4X

B67-43001-203W
SQUARE TUBE WELDMENT
REF

B67-43001-211
SQUARE TUBE
REF

DETAIL D B4-2
SCALE 4X

MASK INSIDE SURFACE AND HOLE (NOT SHOWN) OF CONTOURED MALE EYE PRIOR TO POWDER COATING

D3440-9 TUBE DETENT CLIP BASE
MASK THREADED HOLE (NOT SHOWN) PRIOR TO POWDER COATING

DETAIL F C2-2
SCALE 4X

RELEASED
2014-12-08

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		B67-43001-09	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	AFT BLADE FOLD ASSY WELDMENT	NTS
DATE	14.07.24	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	OTHER : _____							
Misidentified	☐	Past Due								